

FOR STH

Work Order ID 78619

78619

Page 1

January-11-12 2:52:01 PM

Item ID: D3230-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 11/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3230	Rev C

110 0.00
110 Large Fab
 Large Fab Memo 0.00
 Large Fab

PL 12.01.07 *14* *0*

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
 2- Drill and c/sink holes
 3- cut mesh as per dwg
 4 -Deburr & Remove all Markings From Material
 5-Weld bushings and fabricate basket wedge assembly as per D3230
 LOOK AT DWG FRONT MESH MUST BE WELDED INSIDE
 A/R SS ROD Batch: 117884

120 0.00
120 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

PL 12.01.27 *1* *0*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

140

Powdercoat
Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

**** if necessary****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Handwritten: 1X PM 12/01/30

Handwritten: M119480

Handwritten: 2-30 400 OF 3-50

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12-01-31

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Picklist Print

January-11-12 2:52:05 PM

Page 1

Work Order ID: 78619

78619

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2232-3

Manufactured

No

110

Each

6.0000

2

2

D2232-3

Basket Hinge

**

Location

Loc Qty

Loc Code

WA005

6

75581

6

D2327-3

Manufactured

No

110

Each

36.0000

2

2

D2327-3

Spacer Bushing

**

Location

Loc Qty

Loc Code

WA005

36

74782

15

75564

1

71229

20

D3759-1

Manufactured

No

110

Each

253.0000

5

5

D3759-1

Bushing

**

Location

Loc Qty

Loc Code

WA005

253

66489

2

74443

50

74783

201

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item Name: Basket Wedge Assembly

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D3230-041

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

110 sf

808.4490

5.15

5.421053

M304EX0 75-16F

Expanded Metal Flat SS

**

PL 12-01-24

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

808.4488750

117197

102.9036

117896

38.3264

118153

76.8473

118248

3.0983

118597

21.06788

118955

82.17

119180

53.6958107

119729

110.339584

120153

320

110

f

133.4947

25.2966

26.628

**

5.4210

M304TS0.750W.065

Purchased

No

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

111.8304785

117636

67.9987

118773

43.8317785

WA007

15.5974906

116267

14.628472

116763

0.9690186

WA035

6.0667

118181

6.0667

26.628" 11.6212522

14.628472

0.3782

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78619 M.L.J.
12/01/11

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
09.02.19
PER ECN 05-534

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	D3230	SHEET 1 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

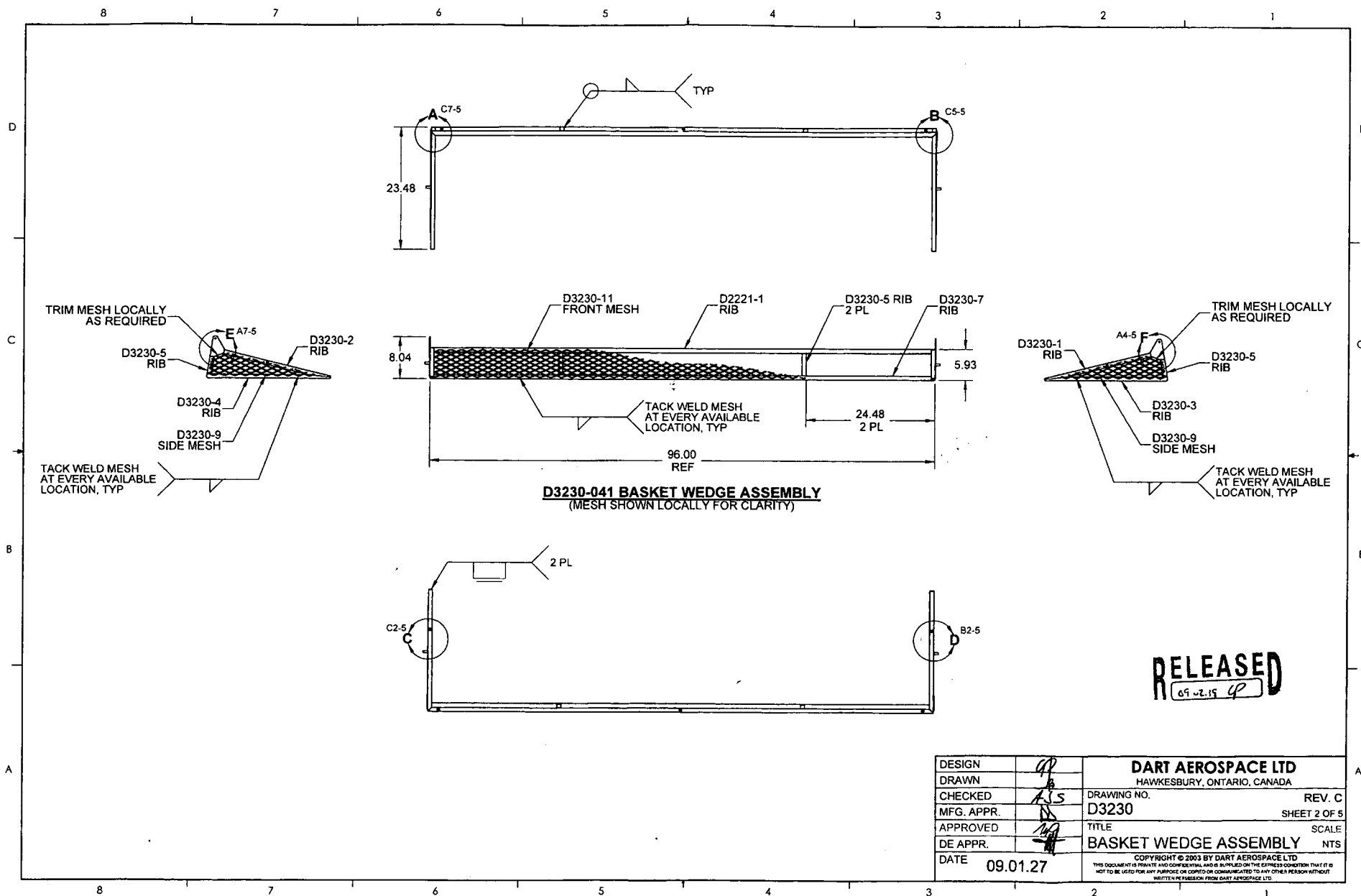
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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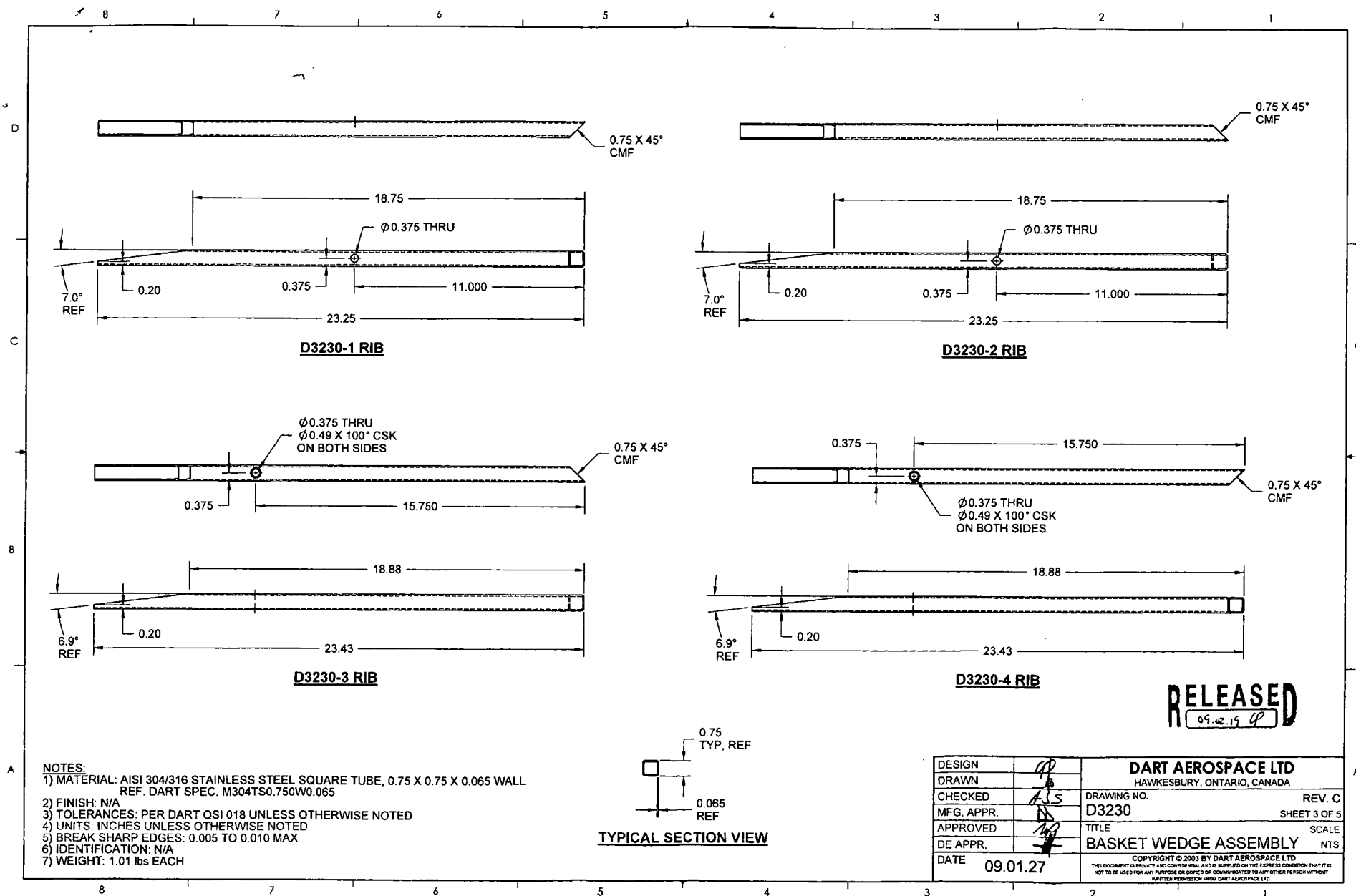
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09.02.19 LP

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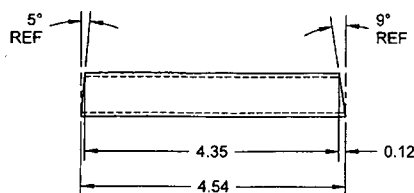
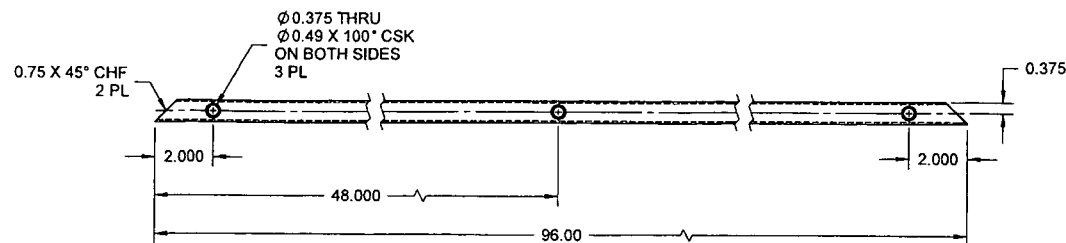
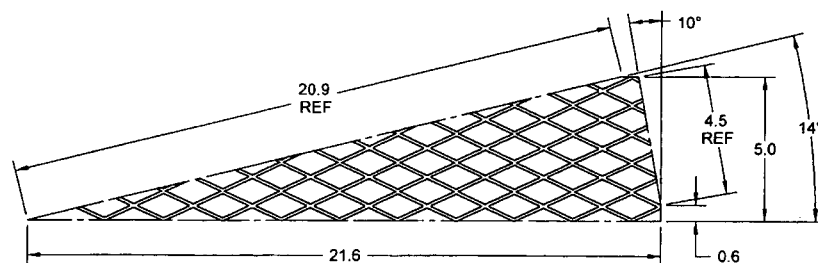
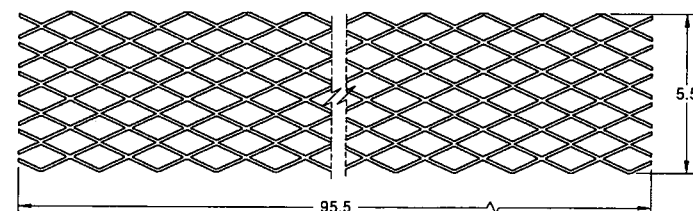
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**D3230-5 RIB****D3230-7 RIB****D3230-9 SIDE MESH****D3230-11 FRONT MESH****NOTES:****1) MATERIAL:**

D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL

REF. DART SPEC. M304TS0.750W0.065

D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL

REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A**3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED****4) UNITS: INCHES UNLESS OTHERWISE NOTED****5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX****6) IDENTIFICATION: N/A****7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs**

D3230-9 = 0.20 lbs; D3230-11 = lbs

RELEASED
09.01.27

DESIGN		DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 4 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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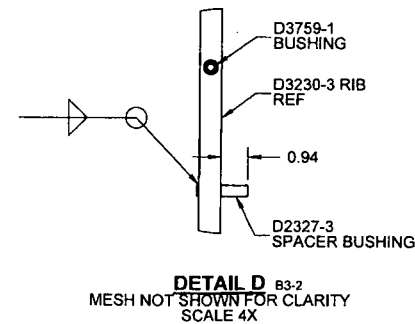
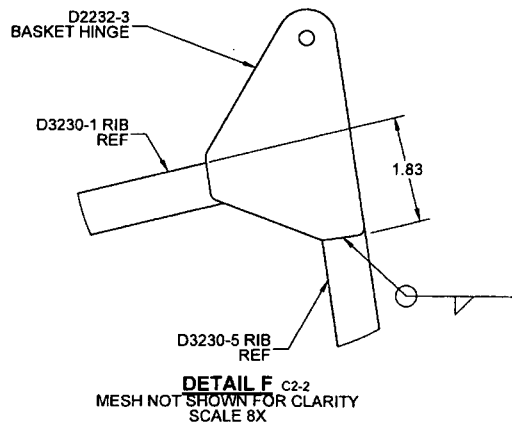
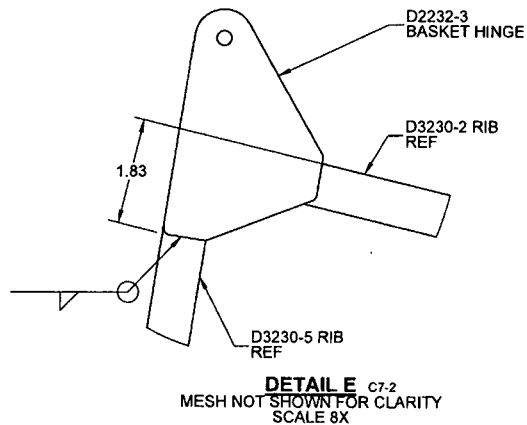
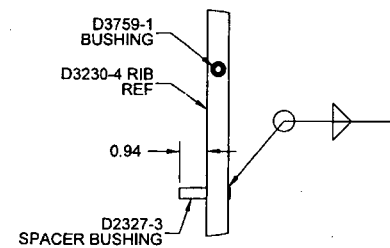
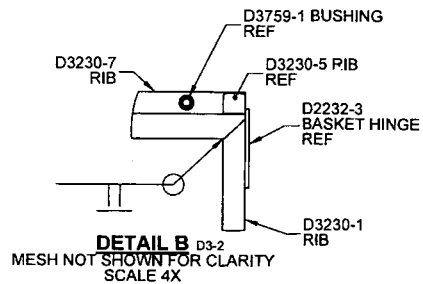
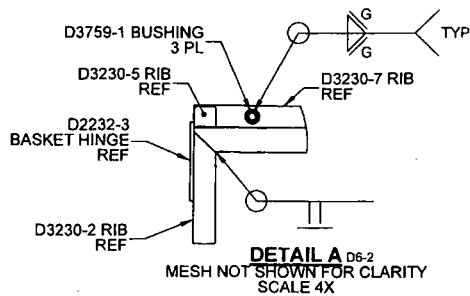
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69-2119

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3230	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET WEDGE ASSEMBLY	NTS
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